

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021959**Date Inspected:** 22-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW repair welding of cope holes located on PCMK OBG 13AE saddle anchor plate, various grillage welds. Welder was identified as 216086. QC was identified as ABF Bao Qian (QC1). Weld variables recorded by QC1 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as verbally identified by QC1. QC1 informed this QA Inspector that the above noted repairs were the result of visual testing indications observed by ZPMC QC personnel.

SMAW tack welding of plate SA3173-X4032A to plate SA3013A-X4031A located on PCMK OBG 13AW. Welder was identified as 200569. QC was identified as ABF CWI Li Shi You (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-FCM-1 as verbally identified by QCA2. QC2 and QCA2 informed this QA Inspector that they did not know the weld number because the assembly was in the fit-up stage of fabrication. See photo of tack welded assembly below.

SAW welding of weld joint SEG3020AP-002 located on PCMK OBG 14W. Welder was identified as 045265. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation

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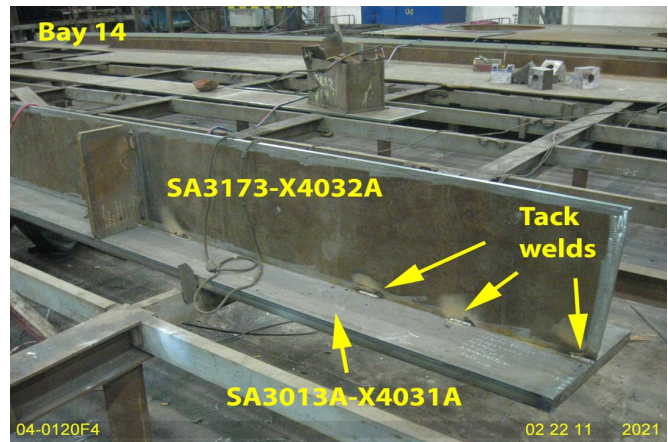
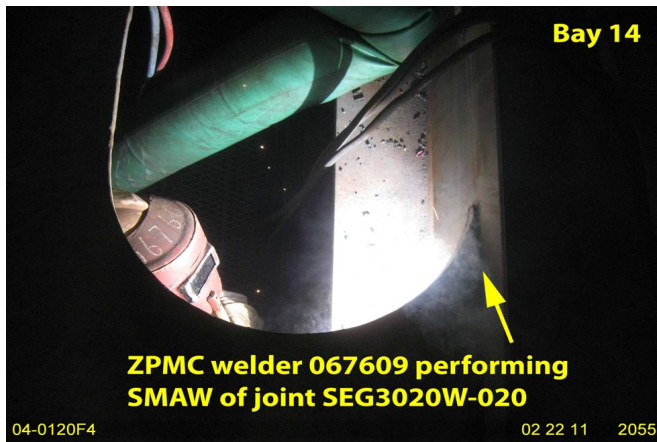
and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2221-B-L2c-S-2 as verbally identified by QCA2.

SMAW welding of weld joint DP3172-001-019 located on PCMK OBG 14W. Welders were identified as 037780, 066480. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2212-TC-U4b-FCM-1 as verbally identified by QCA2.

FCAW welding of weld joint SEG3020BB-112 located on PCMK OBG 14W. Welder was identified as 067949. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA2.

SMAW welding of weld joints SEG3020W-020, 022 located on PCMK OBG 14W. Welders were identified as 066038, 067609, 067764. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2. See photo below of welder 067609 welding joint SEG3020W-020.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer